

Work Order ID 87047

87047

Page 1

Tuesday, July 10, 2012 2:22:14 PM

Item ID: D4019-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib

Start Date: 7/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/20/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

mf

Date:

12-01-12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4019

D

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4019
2- Drill hole as per dwg
3- remove identification marks and deburr

6 CC 12-11-26

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

6 SS 12-11-27

120

Identify as per dwg & Stock Location:

WA

0.00

120

Packaging

Memo

0.00

Packaging

6 SS 12-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87047

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/11/28 JF

R12-125

Picklist Print

Tuesday, July 10, 2012 2:22:13 PM

Page 1

Work Order ID: 87047

Parent Item: D4019-1

Parent Item Name: Rib

Start Date: 7/10/2012

Required Date: 7/20/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C as per dwg revC DD 10.04.20 verified by:EC
IPP Rev:D as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS0.750W.062 6061-T6 SQ Tube .75 x .75 x .062W		Purchased	No			100	f	359.5789	4.73	29.873684		CC 12-11-26	

Location

MAT013

122200

Loc Qty

359.5789

359.5789

Loc Code

~~29.873684~~

29.873684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

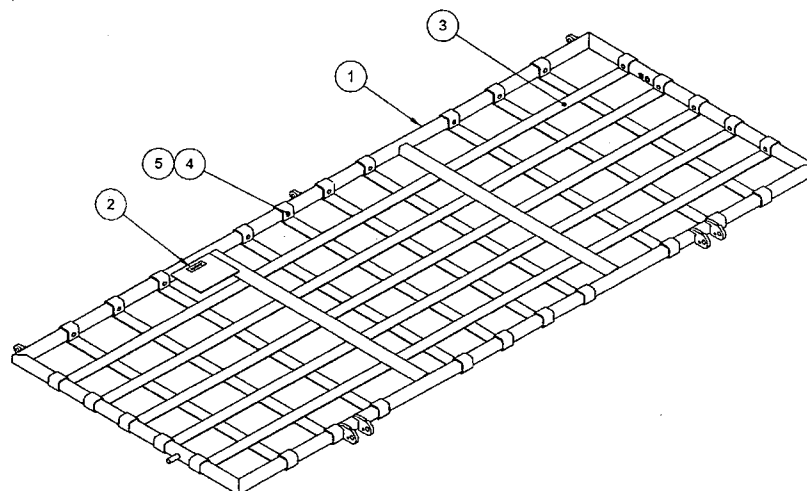
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4019-041	LIGHT LID SHORT BASKET ASSY
1	1	D4019-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-043	WEBBING (SHORT BASKET)
4	30	MS20600AD4W3	BLIND RIVET
5	30	NAS1149DN416J	WASHER



D4019-041 LIGHT LID SHORT BASKET ASSY

#87047

RELEASED
10.08.12
ECN 10-546

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 4.83 lbs

D	REORGANIZED BILL OF MATERIALS. SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-243, UPDATED VIEW E ACCORDINGLY (A7-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
C	MS20600AD4W3 WAS MS20600AD4W5; BOM & (B3-2)	JPH	10.04.06
B	BOM: INSERTED QTY 1 D2728-1 AS ITEM 4 & QTY 1 D4086-243 PLACARD AS ITEM 11. ITEMS RENUMBERED AS REQD. DETAIL E ADDED (A7-2) & (D5-2). SECTION B-B REV'D (D6-3) DIM ADDED (B4-3); WELD SYMBOL REVISED (D5-3)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	ALS		
CHECKED	ALS		
MFG. APPR.	ALS		
APPROVED	ALS		
DE APPR.	ALS		
DATE	10.08.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4019** REV. D
SHEET 1 OF 4
TITLE **LIGHT LID SHORT BASKET** SCALE NTS

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8 7 6 5 4 3 2 1

D

D

C

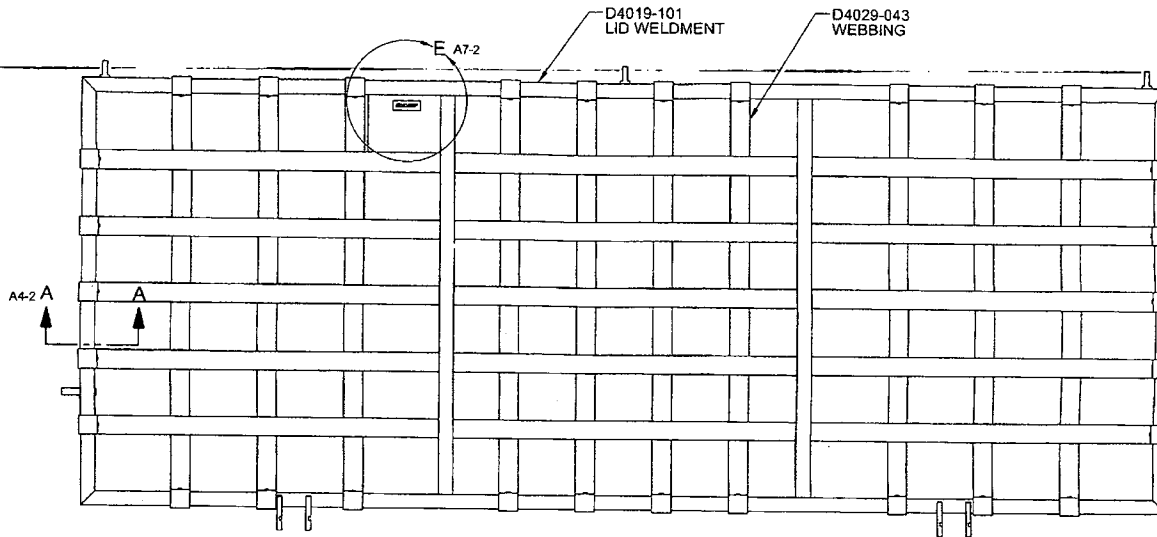
C

B

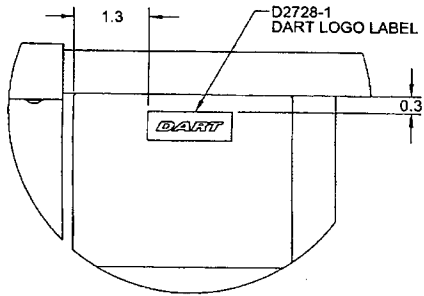
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A

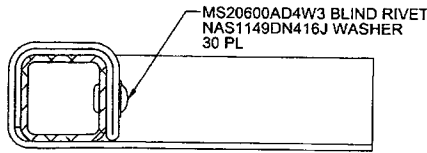
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D4019-041 LIGHT LID SHORT BASKET ASSY



DETAIL E D5-2



SECTION A-A C7-2

87047

RELEASED
10-08-12

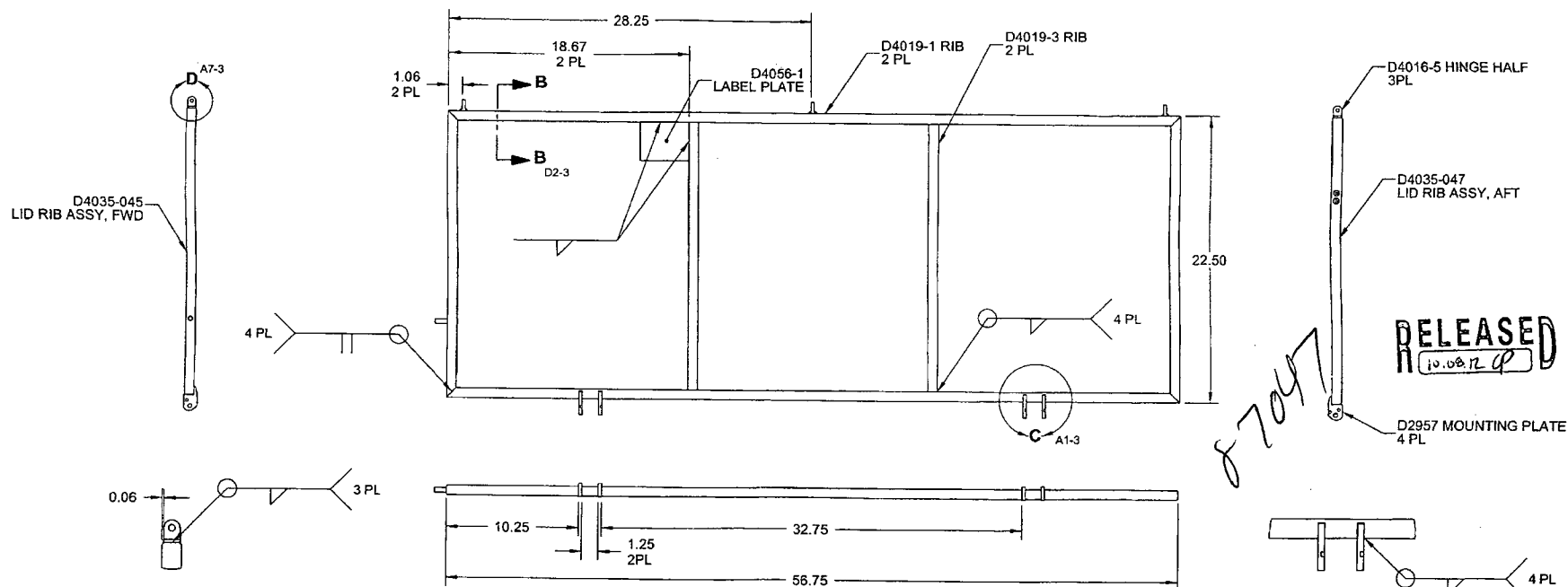
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D4019	REV. D
MFG. APPR.	MP	SHEET 2 OF 4	
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LIGHT LID SHORT BASKET	
DATE	10.08.05	NTS	

8 7 6 5 4 3 2 1

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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4019-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	3	D4016-5	HINGE HALF, LIGHT LID
3	2	D4019-1	RIB
4	2	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET

SECTION B-B C6-3



DETAIL D C7-3

D4019-101 BASKET LID WELDMENT ASSY

DETAIL C C3-3

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.32 lbs
- 8) WELD PER DART QSI 004

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	MS	D4019	SHEET 3 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	LIGHT LID SHORT BASKET	
DATE	10.08.05	NTS	
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